

# Work Order ID 85786

June-15-12 10:46:44 AM

**\*85786\***

Page 1

Item ID: D3245-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door Assembly

Start Date: 15/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/15 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3245 C

100 Pick Kit 0.00

**\*100\***

Packaging Memo 0.00

Packaging

110 0.00

**\*110\***

Small Fab Memo 0.00

Small Fab

1-Install Studs and Gromets as per Dwg D32453-Bond Gasket using 3M  
ADHESIVE as per Dwg D32451/R 3M 1300/1300L ADHESIVE  
Batch: M120954

120 QC5- Inspect part completeness to step on W/O 0.00

**\*120\***

QC Memo 0.00

Quality Control

5/17/06/12

(46)

12/06/21

12/06/28

# Work Order ID 85786

**\*85786\***

Page 2

June-15-12 10:46:44 AM

Item ID: D3245-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Door Assembly

Stop **\*NS2\***

Start Date: 15/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: ST 233 0.00

**\*130\***

Packaging

Memo

0.00

Packaging

Cx

SD  
12-6-27

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/6/289D

MR

12-06-27

# Picklist Print

June-15-12 10:46:48 AM

Page 1

Work Order ID: 85786

**\*85786\***

Parent Item: D3245-043

**\*D3245-043\***

Parent Item Name: Door Assembly

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2351-20-012-C3Y		Purchased	No				Each	3.0000		80			
<b>*2351-20-012-C3Y*</b>									<b>**</b>				
STUD													

Location

Loc Qty

Loc Code

399

3

121499

3

127H-35

Purchased

No

100

Each

260.0000

8

80

**\*127H-35\***

HALF GROMMET

**\*\***

Location

Loc Qty

Loc Code

GA

16

119545

16

ST378

236

121827

236

ST398

8

117203

5

118261

3

D3245-3

Manufactured

No

110

Each

5.0000

1

10

**\*D3245-3\***

Door

**\*\***

Location

Loc Qty

Loc Code

GA

5

77821

5

EP 12/06/27

M122149 04

EP 12/06/28

04

EP 12/06/21

B78626 (1x)  
B85092 (5x)

# Picklist Print

June-15-12 10:46:48 AM

Page 2

Work Order ID: 85786

\*85786\*

Parent Item: D3245-043

\*D3245-043\*

Parent Item Name: Door Assembly

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3245-7

Manufactured No

110

Each

12.0000

1

10

\*D3245-7\*

\*\*

Gasket

Location

Loc Qty

Loc Code

GA

12

83197

12

*Handwritten signature and date: 12/06/21*

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

### FAULT CATEGORY

Landing Gear	Hardware	General	Maintenance
<input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other    
			<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material

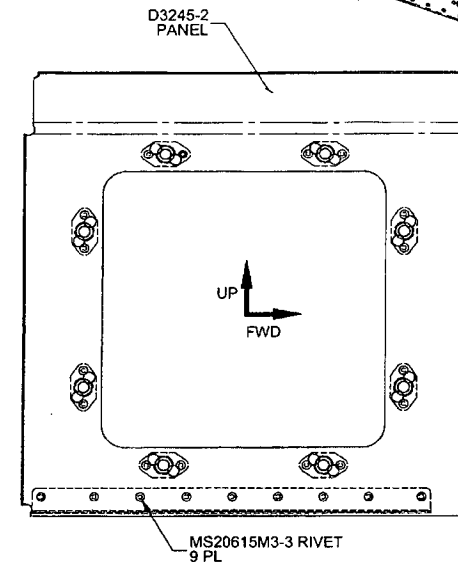
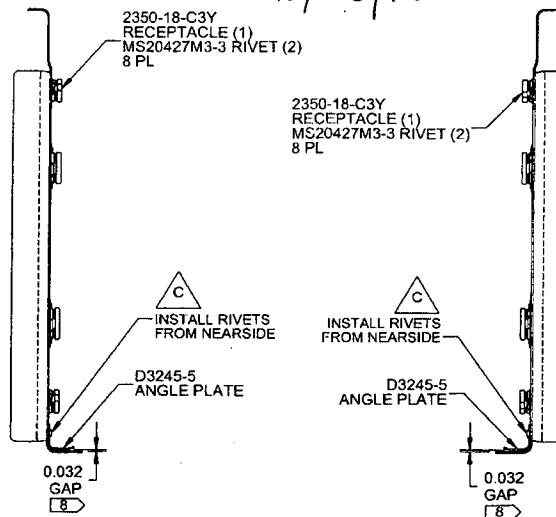
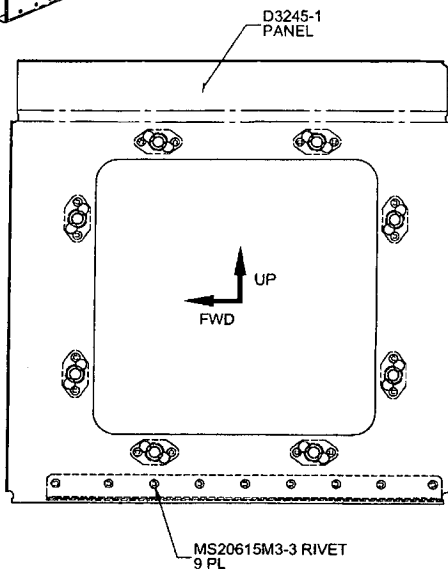
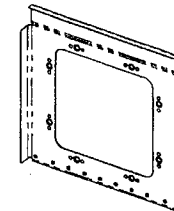
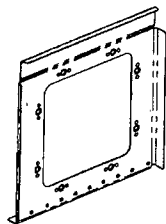
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 85786 MLJ

12/06/15

D3245-041 ACCESS PANEL ASSY (LH)

D3245-042 ACCESS PANEL ASSY (RH)



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C	ADDED NOTE 8, SHEET 1, SPECIFIED RIVET ORIENTATION (B4-1, B5-1), CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2), HOLE SIZE WAS 0.098, 9 PLACES (D6-6), HOLE SIZE WAS 0.219, 8 PLACES (D7-5), REF: PAR 12-165	RP	12.04.11
B	REMOVE Ø0.204 HOLES FROM D3245-1/1F, REMOVE MS21050-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042; HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN PINS TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB	DRAWING NO. D3245	
CHECKED	A.P.	REV. C	
MFG. APPR.	[Signature]	SHEET 1 OF 7	
APPROVED	[Signature]	TITLE ACCESS PANEL ASSY	
DE APPR.	[Signature]	SCALE NTS	
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED  
2012-05-07

D3245-3 DOOR

2351-20-012-C3Y STUD  
127H-35 GROMMET  
8 PL

C

8.00  
REF

8.00 REF

D3245-7 GASKET  
REFINSTALL D3245-7  
GASKET ON THIS SIDE  
6**D3245-043 DOOR ASSY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

C

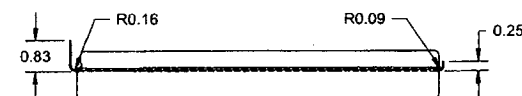
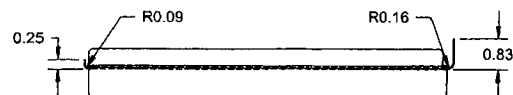
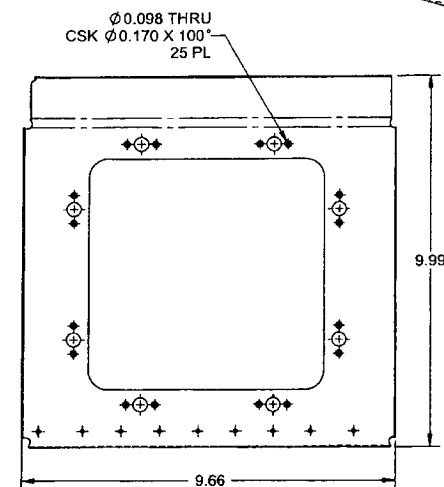
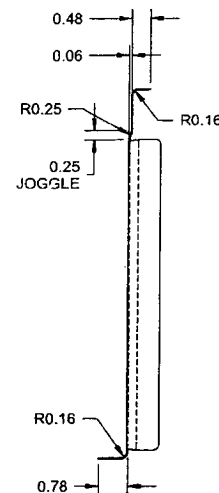
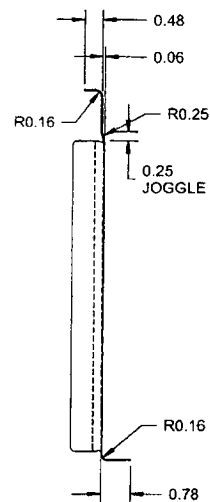
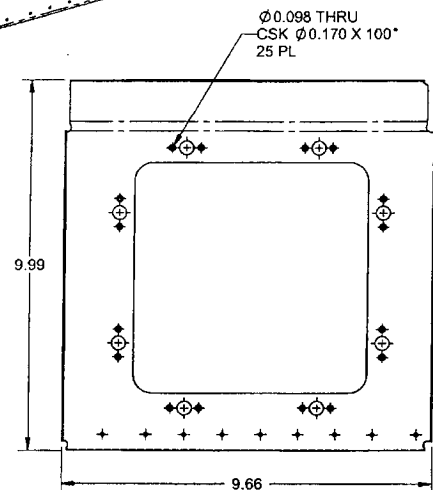
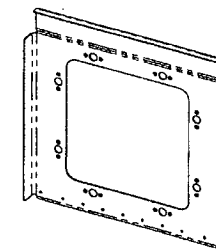
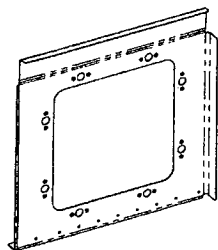
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO. <b>D3245</b>	REV. C
MFG. APPR.	MB	SHEET 2 OF 7	
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	<b>ACCESS PANEL ASSY</b>	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

05786

RELEASED  
2012-05-07



**D3245-1 PANEL (LH)**

**D3245-2 PANEL (RH)**

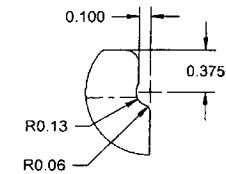
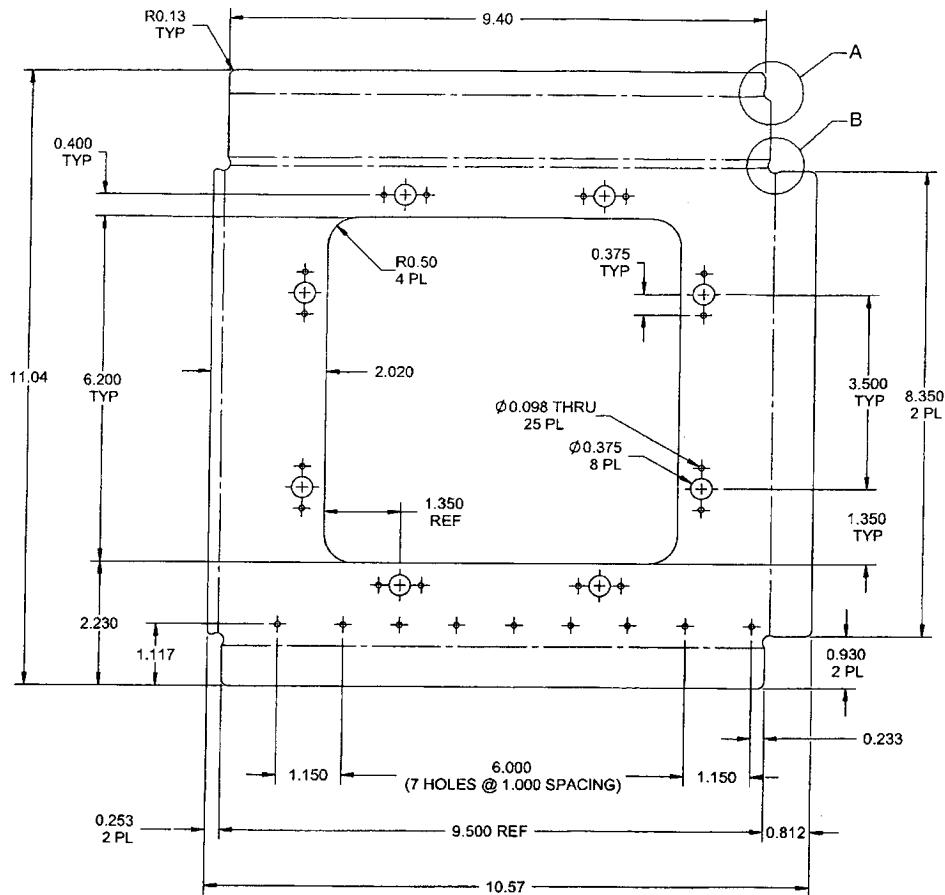
**NOTES:**

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

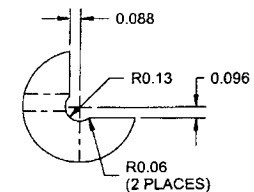
RELEASED  
2012-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





**DETAIL A: RELIEF**  
SCALE 1:1



**DETAIL B: RELIEF**  
TYP. 4 PL  
SCALE 1:1

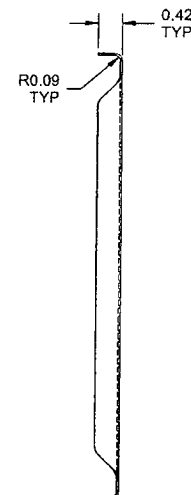
RELEASED  
2012-05-07  
WPD

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70-lbs

**D3245-1F PANEL FLAT PATTERN**

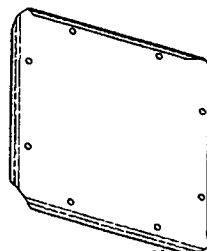
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. <b>D3245</b>	REV. C
MFG. APPR.	WPD	SHEET 4 OF 7	
APPROVED	WPD	TITLE	SCALE
DE APPR.	WPD	<b>ACCESS PANEL ASSY</b>	NTS
DATE	12.04.11	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



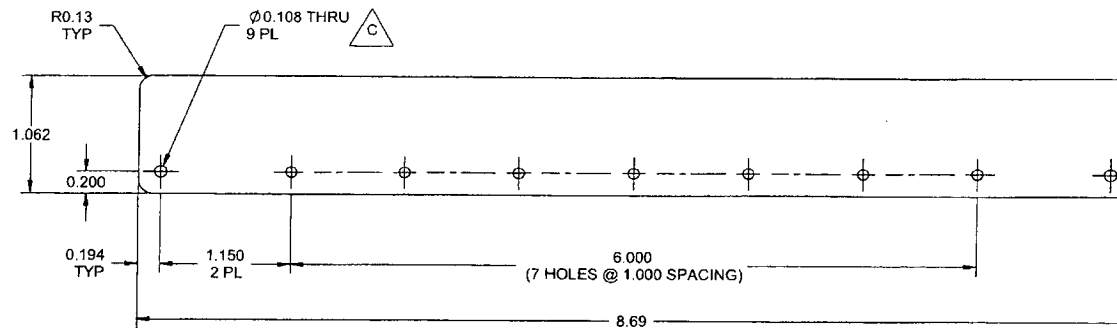
**D3245-3 DOOR**  
(MADE FROM D3245-3F)

2012-05-07

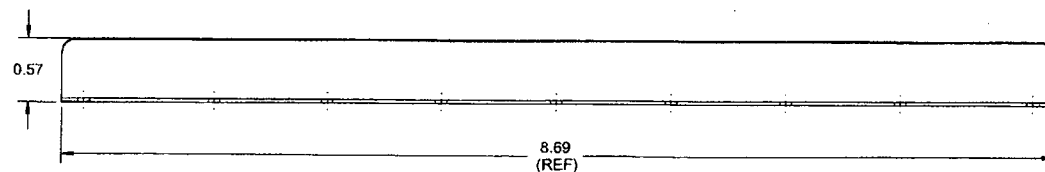
- NOTES:**  
1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH,  
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR  
ASTM A240 OR ASME SA240  
(REF. DART SPEC. M304S22GA)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.66 lbs



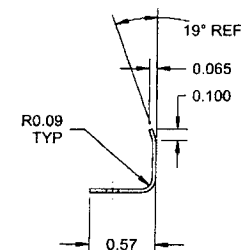
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. 0
MFG. APPR.	<i>[Signature]</i>	<b>D3245</b>	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>ACCESS PANEL ASSY</b>	N/T
DATE	<b>12.04.11</b>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND THE CONTENTS HEREON SHOULD NOT BE HOT TO BE USED FOR ANY PURPOSE OR ON ANY EQUIPMENT TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



**D3245-5F FLAT PATTERN**



**D3245-5 ANGLE PLATE**  
(MAKE FROM D3245-5F)

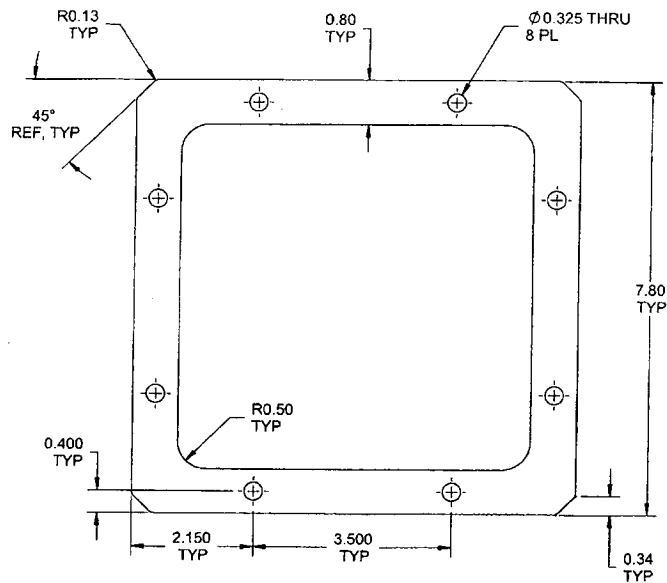


REL. 1000  
2012-07-07

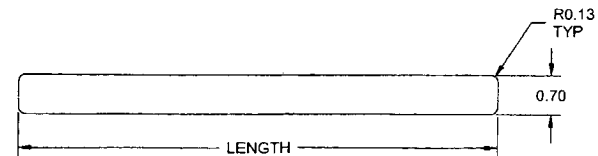
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	F	D3245	SHEET 6 OF 7
APPROVED	AND	TITLE	SCALE
DE APPR.	AND	ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232  
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

RELEASED  
2012-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3245	SHEET 7 OF 7
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	ACCESS PANEL ASSY	NTS
DATE	12.04.11	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	